forde show

Memo

Quality Control

Work Orden September-30-1.			shp Oct	. <sub>∥</sub> *107	748*						www	Page 1
Item ID: Revision ID:	D4019-041			Accept	*N900	<b>040</b>	100	<b>)*</b>	Setup	Start	*N	S1*
Item Name:	Light Lid Sho	ort Basket Assembly								Stop	*N:	S2*
Start Date:	9/30/13	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	10/10/13	<b>Req'd Qty:</b> 1.00	*1*		<b>Customer:</b>							
Reference:		1						_		~. ·		
Approvals:	Process Pla	an: _ \/	Date:	Tooling:	Da	ate:		. <b>F</b>	Run	Start	*N	R1*
	QC:	V	Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
D4019	F											
100		Weld per dwg A/R Alu	' <del></del>	0.00					. ,			
*100*		Large Fab	1239			(Tx	)		M	13 -	D . 0	2
Large Fab		Memo		0.00			/					
Large Fab		D4019-3, w	eld top and bottom then	D4019 using DT9606B. Who make a small hole in the wel 9-3 Rib. Let it cool down, the	d to let air out.							
			TO GET THE ACID A	RNERS. GRIND OFF CORN ND ALODINE OUT OF BAS								
		2- weld hing	ge, label plate and Mour	nting plates as per dwg D4019	)							,
110		QC9- Inspect visual per	QS1004- Fusion Welds	0.00								/DAD
*110*									V.	3-10	[O:	၂ ( ၇၅)

0.00

NCR: \	⁄es	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE			_	
											QA Closed	Dat	e:	
Work Orde	or.					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS		
Part N	- - ۱۰۰					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet od. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	T				Descri	ption of work order update		Initial	Ac	tion	Sign &	1		· · · · · · · · · · · · · · · · · · ·
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	۱	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
						······································	AUL	T CATE	GORY					
Landi		Bending Centre No Cracks Crushed/C Cuffs Heat Trea	Crimped. t		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		4	on Incomplete ions Incomplete/ nance	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned	ect lissing Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
* *	_	Inspection Ripples in	· ·	Tube	_	Cut Too Short Drill Holes	-	Misread Offset	l		Power Loss	/Surge		Other

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Orden				<sup>*</sup> 107	7748*						Page 2
Item ID: Revision ID: Item Name:	D4019-041 Light Lid Sh	ort Basket Assembly		Accept	*N900	<b>040</b>	100	)*	Setup Sta	1 7	S1* S2*
Required Date:	9/30/13 10/10/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Reference: Approvals:	Process P	lan:	Date:	_ Tooling: _	Da	nte:			Run Sta Sto	<b>/ </b> "	R1*
•	QC:		Date:	<b>SPC (Y/N):</b>	Da	nte:				*N	R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC5- Inspect part compl	eteness to step on W/O	0.00							
*120* QC Quality Control		Memo		0.00					13	10.07	( 09
130		Chemical Conversion Co	oat per QSI005 4.1	0.00				,	26	9 7.13-10	7 Ø
*130* HandFinish		Memo		0.00					110	115-16	ノ·0

140

Weld per dwg A/R Aluminum rod Batch:\_\_\_\_\_

0.00

\*\*\*ENSURE TO RINSE CAREFULLY ACID AND ALODINE\*\*\*

\*140\* Large Fab

Hand Finishing

4123928

Memo

0.00

Large Fab

1- weld (4) corners

St 13.10.09

		DQA:	Date:	
 	 MADRIC ORDER MONE CONFORMANCE / LIDDATE			

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DISPOSITION											QA Closed:	Date	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT/	_	
Part N						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	11	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator			i										
Material													
Setup													
Other		. ,											
Process	_												
Supplier	_										ļ		
Training													
Unapproved											<u> </u>		
			<del></del>				AUL	T CATE	GORY			_	
Landii					_	General				r	1	_	٦
1	-	ending			o/s	Bend	$\vdash$	Grain		<u> </u>	Ovalized		Pressure/Forced
		acks	t Concer	itric to	<sup>0/3</sup>  -	BOM/Route Broken/Damaged	$\boldsymbol{\vdash}$	Hardwa		-	Over/Under Part Incorred	<b>├</b>	Temperature/Cure Weld
	—		Crimped.		-	Burrs	-	•	on Incomplete ions Incomplete/	/Unclose	Part Lost/Mi	<b>-</b>	Wrong Stock Pulled
	_	usneu) ıffs	zrimpeu,			Contamination	-	Mainte		Officieal	Part Moved	22111B	
	-	eat Trea	+			Countersink	$\vdash$	Mislabe			Positioned V	Vrong	
	Inspection Strip in Tube Cut Too Short			$\vdash$	Misread		-	Power Loss/	_	Other			
Ripples in Bend Drill Holes				$\vdash$	Offset	•	<u> </u>	J. 5 c. 2555/		10			
			Drawing	-		Calibration			<u> </u>				
<del></del>			Finish	Out of Sequence									
Wave/Twist in Tube				Folio	$\vdash$		Dimensions						

September-30-13 12:44:25 PM

september 30 1:	7 12. 77.20 1												
Item ID: Revision ID: Item Name:	D4019-041	rt Basket Assembly		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	IVI	S1* S2*	
Start Date: Required Date: Reference:	9/30/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					IV	. 7/	
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:			Run	Start	*N	R1*	
			Date:	_ SPC (Y/N):	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description QC9- Inspect visual per Q	SI004- Fusion Welds	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp	
*150* QC Quality Control		Memo		0.00					<u>13-10</u>	P0C		09	
160		White Gloss(Ref:4.3.5.1)	oer QSI005 4.3-Alum	0.00									
*160* Powdercoat		Memo		0.00	: 6								
Mag Ab	25	1- touch up co 2- Plug holes 1ST COAT: START TIMI OVEN TEMI FINISH TIMI *********** 2ND COAT: START TIMI OVEN TEMI	E:	of hinge prior to powdercoat				/X,	1 X	M/	\$13+ 113 <sub>1</sub>	10/00	Ī

				DQA:	Date:	•
NCR:	Yes	/ No	WORK ORDER NON-CONFORMANCE / UPDATE			·

							•		QA Closed:	Date:		
Work Ordei	r·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descr	ption of work order update	In	nitial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											į	
Equip/Tooling		İ										
Operator						1						
Material												
Setup	]											
Other		,										
Process												
Supplier	_					1						
Training												
Unapproved								_				
						AULT	CATE	GORY				
Landing	<del>-</del>			_	General	_				7	_	7
<u> </u>	Bending				Bend	-	Grain		<u></u>	Ovalized		Pressure/Forced
<u> </u>	Centre No	ot Concer	ntric to (	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under	<b></b>	Temperature/Cure
<u>  (</u>	Cracks				Broken/Damaged	$\overline{}$		on Incomplete	<u> </u>	Part Incorre	<u>├</u>	Weld
_	Crushed/Crimped Burrs			Burrs	-		ions Incomplete,	/Unclear	Part Lost/M		Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea				Countersink	$\square$	Mislabe	led		Positioned V	<del>-</del>	٦
_	Inspection Strip in Tube Cut Too Short			Misread Power Loss/Surge O			Other					
	Ripples in Bend Drill Holes			Offset					<u> </u>			
	Torque W	aves in E	xtrusion	ո 📙	Drawing	$\bigsqcup$	Out of 0	Calibration				
į	Turning Sequence Finish Out of Sequence											

Wave/Twist in Tube

Work Ord September-30-1				*107748*								Page 4
Item ID: Revision ID: Item Name:	D4019-041 Light Lid Sho	ort Basket Assembly	The second secon	Accept	*N900	740	100	)*	Setup	Start Stop	*NS	-
Start Date: Required Date Reference:	9/30/13 e: 10/10/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	<b>)</b> :						
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		te: te:			Run	Start Stop	"INH	_
Sequence ID/ Work Center I  170  *170* QC Quality Control	ID	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	y		nsp. tamp
180 <b>*180*</b> HandFinish Hand Finishing		Assemble as per dwg  Memo  Install webb	ing as per dwg and label	0.00					9	<u>\$</u>	13-10-10	D. O.

\*190\*

190

Memo

QC5- Inspect part completeness to step on W/O

0.00

0.00

Quality Control

·											
									QA Closed:	Date:	
				DISPOSITION	_			AGAINST DE	PARTMENT/	PROCESS	
·				Rework Scrap Use-as-is Work Order Update	Th	M nermo	lachining Si oforming F	mall Fab Finishing		· · · · · · · · · · · · · · · · · · ·	Engineering Quality Other
			Descri	tion of work order update	Initia	al	Action		Sign &	·	· · · · · · · · · · · · · · · · · · ·
Date	Step	Qty			Chief E	Eng	Descriptio	on	Date	Verification	QC Inspector
					AULT CA	ATEG	ORY				
Bending Bend Bend BoM/Route Broken/Damaged Burrs Cushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence General Bend BoM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes						dware pection ruction intensilabele read set cof Ca	in Incomplete ons Incomplete/Uncle nance ed alibration	ear	Part Incorrec Part Lost/Mi Part Moved Positioned W	st ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Date  Gear  Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in Torque W	Date Step  Gear Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in E	Date Step Qty  Gear  Bending Centre Not Concentric to C Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  Gear General  Bending Bend Centre Not Concentric to O/S Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Cuffs Contamination Cuffs Countersink Inspection Strip in Tube Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing	Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance Chief I  Bending Bend Gracentre Not Concentric to O/S BOM/Route Har Cracks Broken/Damaged Instruction Survey Cracks Crushed/Crimped Burrs Instruction Materials Contamination Materials Contamination Materials Countersink Missipples in Bend Drill Holes Off Instruction Drawing Out	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Initial Chief Eng	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Unitial Action Date Step Qty Description of work order update or Non-conformance Chief Eng Description De	Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  Step Qty Order Update  FAULT CATEGORY  Gear General  Bending Centre Not Concentric to O/S BOM/Route Hardware  Cracks Broken/Damaged Instructions Incomplete  Crushed/Crimped. Burrs Instructions Incomplete  Crushed/Crimped. Cut Too Short Misread Inspection Strip in Tube Cut Too Short Misread Inspection Strip in Tube Cut Too Short Misread Inspection Incomplete Order Misread Inspection Strip in Tube Drawing Drawing Out of Calibration  Rework Scrap Machining Small Fab Machining Thermoforming Finishing Composite  FAULT CATEGORY  Gear General  Bend Grain Hardware Hardware Inspection Incomplete  Inspection Incomplete  Instructions Incomplete/Unclear  Maintenance Mislabeled  Misread Offset  Out of Calibration	Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Initial Action Chief Eng Description Date Step Qty or Non-conformance Chief Eng Description Date Step Qty Or Non-conformance Chief Eng Description Date Date Step Qty Or Non-conformance Chief Eng Description Date Date Date Date Date Date Date Date	Rework Scrap Use-as-is Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Step Qty Description of work order update or Non-conformance Use-as-is Use-as

DQA:

Date:

Wave/Twist in Tube

Work Orde September-30-1.					Page 5						
Item ID: Revision ID: Item Name:	D4019-041 Light Lid Sh	ort Basket Assembly		Accept	*N900	<b>040</b>	100	)*	Setup Sta	1.7	S1* S2*
Start Date:	9/30/13	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date:	10/10/13	<b>Req'd Qty:</b> 1.00	*1*		<b>Customer:</b>						•
Reference:			•						_		
Approvals:	Process P	lan:	Date:	Tooling:	Da	ite:			Run Sta	I <i>Z</i> I	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	Da	nte:			Sto	*N	R2*
Sequence ID/ Work Center II	)	Operation Description	× 250	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		Identify as per dwg & St	ock Location 7	37 042				)	1	10 10	1
*200* Packaging Packaging		Memo	D 40	0.00				_/	- Ψ	12707	<u>//</u>

210

QC21- Final Inspection - Work Order Release

0.00

\*210\*

Memo

0.00

Quality Control

11/13/10-10

MC5 13-10-11

		DQA:	Date:	
NCR· Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

									QA Closea:	Date	•	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
Part N				<del></del>	Rework Scrap Use-as-is Work Order Update	The	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
						<b>'</b> ]		,	] 34ppnen [_]			
Root				Descri	ption of work order update	Initial	Initial Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector	
Doc/Data	_											
Equip/Tooling												
Operator										1		
Material		1										
Setup				+							1	
Other		Į								1		
Process												
Supplier		ļ										
Training		İ										
Unapproved												
		-			F.	AULT CAT	EGORY					
Landin	g Gear				General				_		_	
	Bending				Bend <sup>-</sup>	Grain			Ovalized		Pressure/Forced	
	Centre No	ot Concer	ntric to C	)/S	BOM/Route	Hardy	vare		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct [	Weld	
	Crushed/	Crimped.			Burrs	Instru	ctions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Main	tenance		Part Moved		_	
ſ	Heat Treat				Countersink	Misla	peled		Positioned \	<b>N</b> rong		
	Inspection Strip in Tube				Cut Too Short	Misre	ad		Power Loss/	/Surge	Other	
Γ	Ripples in Bend				Drill Holes	Offse			<del>-</del>			
· [	Torque Waves in Extrusion				Drawing	Out o	f Calibration					
	Turning Sequence				Finish	Out of Sequence						
	Wave/Twist in Tube				Folio	Outsi	de Dimensions					

September-30-13 12:44:24 PM

Work Order ID:

107748

Parent Item:

D4019-041

Parent Item Name:

Light Lid Short Basket Assembly

**Start Date:** 9/30/13

Required Date: 10/10/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.12.07 verified by:EC

IPP Rev:C as per dwg revC DD 10.04.20 verified by:EC

IPP Rev:B as per dwg revA 10.03.15

as per dwg revD DD 10.08.18 verified by:EC

IPP Rev:E 13.07.08 as per dwg rev.E DD

	verf:JLM	IPP REV:F 13.0	08.21 D	WG REV.F / I	ECN 13-624 D	D VERF:JLM	1						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>D4019-1</b> Rib		Manufactured	No			100	Each	2.0000	2	$\mathcal{SM}^2$	13-10	:-01	
				Location		Loc Oty	Lo	oc Code					
				WA005 870	47	2 2				2			
<b>D4019-3</b> Rib		Manufactured	No			100	Each	10.0000	2	SAE	13-,	10-C	2/
				Location		Loc Qty	Lo	oc Code					
		•		WA006 941 941		10 7 3			(2				
D4016-5 Hinge Half, Light Lid		Manufactured	No			100	Each	32.0000	3	SH	13 70	0-01	
				<b>Location</b>		Loc Oty	<u>L</u> c	oc Code					
					577 052	32 12 20		· 27		2			
D2957 Mounting Plate		Manufactured	No			100	Each	16.0000	4	S/15	13-1	0-0	/
				<u>Location</u>		Loc Oty	<u>L</u> c	oc Code					
				(	597	15 15			3	<b></b>			
				WA005 941	16	1							

NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE
	,		

DQA:	
osed:	Date:

	QA Closed: Date:												
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT		
Part N	lo					Rework Scrap Use-as-is			Skid-tube Machining	Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR N	lo				· · · · · · · · · · · · · · · · · · ·	Work Order Update	Thermoforming Finishing Large Fab Composite			Supplier			
Root		Descript				ption of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data						,							
Equip/Tooling													
Operator													
Material	_												
Setup	_												
Other	_	•											
Process	_												
Supplier	_												
Training	_												
Unapproved					-		<u> </u>				<u></u>		1
							AUL	T CATE	GORY				
Landin T						General		۱		_	٦	Г	¬, ,,
<u> </u>	_	ending			~ <del> </del>	Bend BONA/Barras	$\vdash$	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
		entre No acks	ot Concer	ינרוכ נס (	د/د	BOM/Route Broken/Damaged	$\vdash$	Hardwa		<u> </u>	Over/Under Part Incorre	<u> </u>	Temperature/Cure Weld
·	_		Crimped.		-	Burrs	-		on Incomplete ions Incomplete,	/Unclose	Part Lost/Mi	<del>}</del>	Wrong Stock Pulled
<u> </u>		usnea/ ıffs	crimpeu.			Contamination	H	Mainte	· ·	Officiear	Part Moved	rssing [	
<u> </u>		iiis eat Trea	.+			Countersink	-	Mislabe		_	Positioned V	Mrong	
<u></u>			n Strip in	Tube	-	Cut Too Short		Misread		<del> </del>	Power Loss/		Other
<u> </u>		pples in	•	Tube		Drill Holes		Offset	4		J. 5WC1 2533/		- Care
·			aves in E	xtrusio	, <u> </u>	Drawing	$\vdash$	l	Calibration				
ŀ	Turning Sequence					Finish	$\vdash$	Out of Sequence					
ļ	_	_	ist in Tub			Folio	$\vdash$	i i	Dimensions				

September-30-13 12:44:25 PM

Work Order ID:	107748						Ct. 4Th	0/20/12	D
Parent Item:	D4019-041				•			ate: 9/30/13	Required Date: 10/10/13
Parent Item Name:	Light Lid Short Baske	t Assembly		•			Start (	Qty: 1.00	Required Qty: 1.00
<b>D4035-047</b> Lid Rib Assembly, Aft (		Manufactured	No		100	Each	5.0000	$^{2}$ $S(\cancel{z})$	13-10-01
				<b>Location</b>	Loc Oty		Loc Code		
				WA005	5				
				104422	5			_(.2)	
D4029-043		Manufactured	No		180	Each	7.0000	1 1	DAS 26
Webbing (Short Basket)								care a second a second as	9-89
				<b>Location</b>	Loc Qty		Loc Code		
				ST483	7				
				<u> 56957</u> 56967	4			<del>//</del>	
D4056-1		M	No	30907	100	Each	17.0000	1 1	
Label Plate		Manufactured	140		100	Lacii	17.0000	SAD	13-10-01
				<b>Location</b>	Loc Qty		Loc Code	<b>0</b> /1-	_
				WA004	17			_	
				85016	17				242
MS20600-AD4W4		Purchased	No		180	Each	4,790.0000	30 30	DAS: 26
Rivets		T di ciidoca							9-89
				<b>Location</b>	Loc Qty		Loc Code		
				ST	3870				
				125577	3870				
				ST311	374				
				123900	350				
				125406	. 24			· · · · · · · · · · · · · · · · · · ·	
				ST506	546				
			3.1.	125654	546		507.0000		
NAS1149DN949J		Purchased	No		180	Each	597.0000	30 30	13-10-10
Washer				*	1 04		Los Codo	2x m/	13-10-10 26330
				Location	Loc Oty		Loc Code	28x m	126926
				ST293 120833	597 2			<u> </u>	10W 104
				m126926	595				
				111120720	373				

											DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE	QA Closed:	Date		
			<del>,</del>					<u> </u>						
Work Ord	ler:					DISPOSITION			AGAINST DEPARTMENT/PROCESS					
						Rework			Skid-tube	Crosstube	]	Water Jet	Engineering	
Part	No.		·= ,			Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality	
						Use-as-is	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR No.					·	Work Order Update	_		Large Fab	Composite	]	Supplier		
Root Desc						tion of work order update	Τ	Initial	Ac	tion	Sign &		<u> </u>	
Cause **		Date	Step	Qty		or Non-conformance	CI	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data							T							
Equip/Tooling														
Operator							ı							
Material		]					1							
Setup							1	,						
Other														
Process	L													
Supplier														
Training	L	<u> </u>					1							
Unapproved														
							AU	LT CATE	GORY					
Land	ing (	7				General	_	-			-	_	_	
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to (	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
	Crushed/Crimped.					Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	L	Cuffs				Contamination		Mainte	nance	<u>L</u>	Part Moved			
	$\bot$	Heat Trea	it			Countersink		Mislabe	led		Positioned \	Vrong	<del>-</del>	
1	1	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss	Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

\* 4

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio .

September-30-13 12:44:25 PM

Work Order ID:

107748

Parent Item:

D4019-041

Parent Item Name:

Dart Logo Label Small

Light Lid Short Basket Assembly

D2728-1

Manufactured

No

180

Each

-1.0000

)

**Start Date:** 9/30/13

Start Qty: 1.00

Required Date: 10/10/13

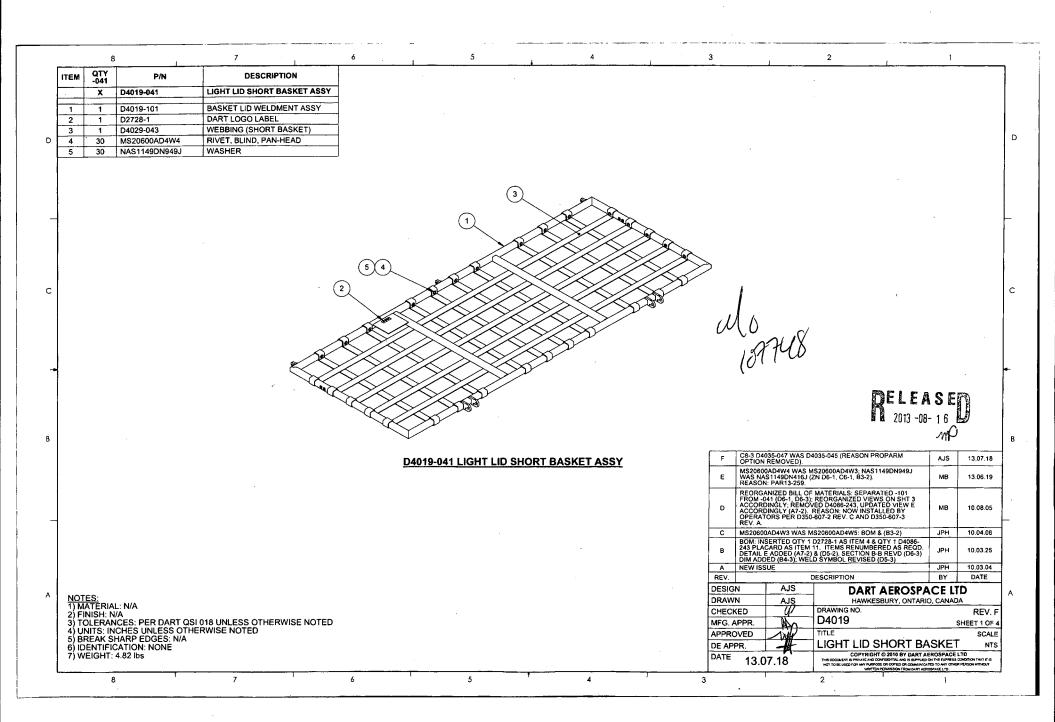
Required Qty: 1.00

N 13-10-10

		DQA:	Date:	
ICP: Vos / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

	,									QA Closed:	Date	e:
Work Orde	r·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR OIGE				<del> </del>	Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	n.				Scrap	┪ ┃	Machining Small Fab			Pro	d. Eng. Coor.	Quality
	·				Use-as-is	†   <sub>Th</sub>	Thermoforming Finishi			Rec/Sto	Other	
NCR N	o				Work Order Update	] [ ]	Large Fab Composit			,	Supplier	
Root		<u> </u>		Descri	ption of work order update	Initia	al [	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief I			cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator						1						
Material											ŀ	
Setup												
Other		:										
Process		į										
Supplier												
Training		ļ									1	
Unapproved												
	•				F	AULT C	ATEG	ORY				
Landin	g Gear				General							
	Bending			•	Bend	Gra	ain			Ovalized	[	Pressure/Forced
	Centre No	ot Concei	ntric to (	o/s	BOM/Route	Har	dwar	e		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	pectio	on Incomplete		Part Incorre	ct [	Weld
	Crushed/	Crimped,			Burrs	Inst	tructi	ons Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	inter	nance		Part Moved	_	
	Heat Treat				Countersink	Mis	slabel	ed		Positioned V	<b>N</b> rong	
	Inspection Strip in Tube				Cut Too Short	Mis	sread			Power Loss/	′Surge [	Other
	Ripples in	Bend			Drill Holes	Off	set					
	Torque Waves in Extrusion			1 [	Drawing		Out of Calibration					
Ţ	Turning Sequence				Finish	Out	t of Se	equence				

Wave/Twist in Tube

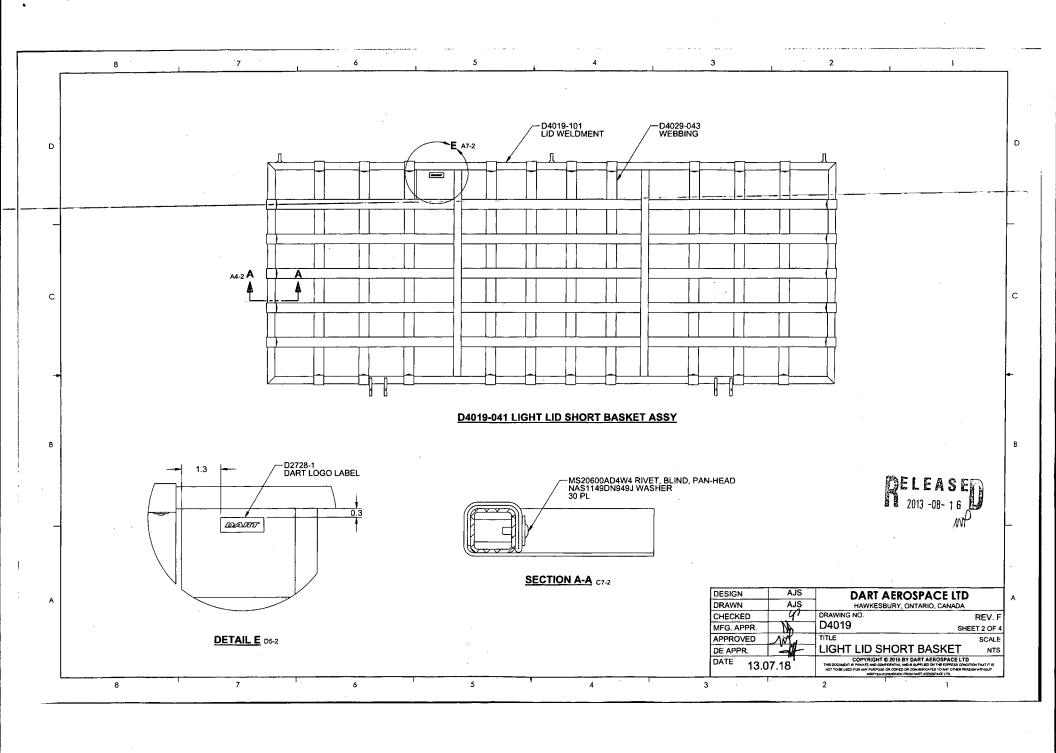


		DQA:	Date:	
NCP: Voc / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

			_						QA Closed:	Date	:			
Work Orde	r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No					Rework Scrap Use-as-is	The	Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor.	Engineering Quality Other			
NCR N	0				Work Order Update		Large Fab	Composite	1100,000	Supplier				
Root				Descri	ption of work order update	Initial	A	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector			
Doc/Data														
Equip/Tooling	_													
Operator						ļ								
Material	_													
Setup														
Other							1			1				
Process		[							1					
Supplier									;					
Training														
Unapproved		<u></u>												
						AULT CAT	EGORY			·				
Landing	g Gear				General				,	_				
_	Bending			•	Bend	Grain			Ovalized		Pressure/Forced			
_	Centre No	ot Concer	ntric to (	o/s	BOM/Route	Hardv	vare		Over/Under	tolerance	Temperature/Cure			
_	Cracks				Broken/Damaged		ction Incomplete		Part Incorre	ct	Weld			
<u> </u>	Crushed/0	Crimped.		_	Burrs	<del></del>	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs				Contamination	Main	tenance		Part Moved					
L.	Heat Treat			<u></u>	Countersink	Misla	peled		Positioned \		<del></del> 1			
	Inspection Strip in Tube				Cut Too Short	Misre	ad		Power Loss,	/Surge	Other			
	Ripples in	Bend			Drill Holes	Offse								
L	Torque W	aves in E	xtrusio	า 📙	Drawing	Out o	f Calibration							
	Turning So	equence		1	Finish	Out o	f Seguence							

Wave/Twist in Tube

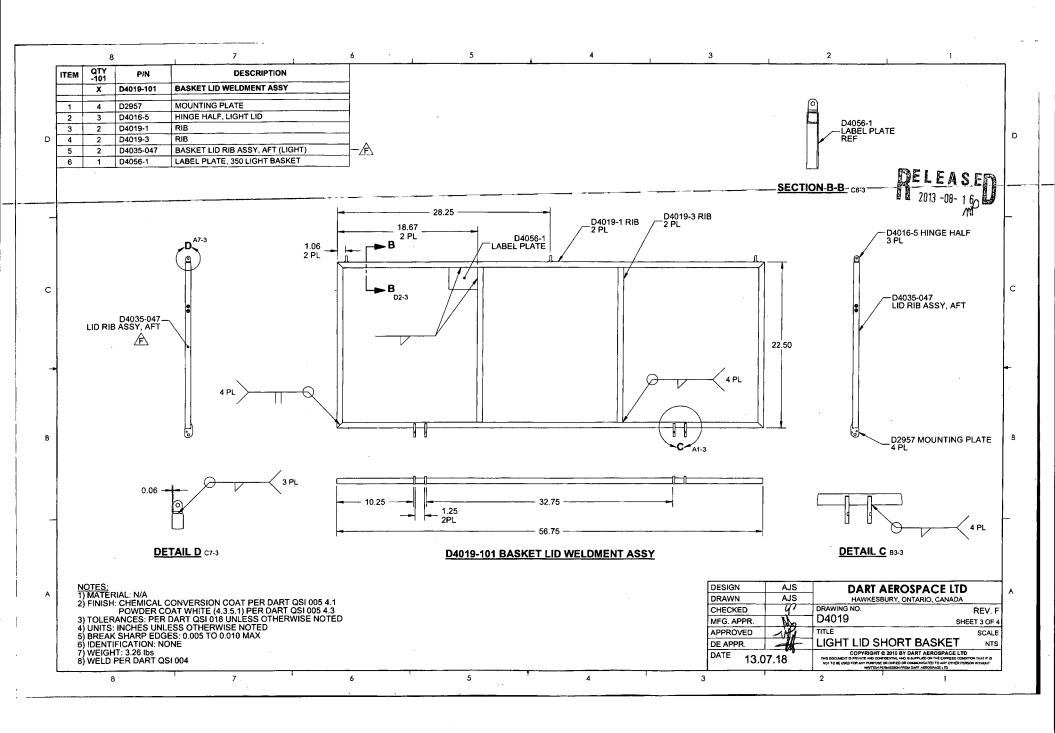
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Date	2:	
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N NCR N					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Prod. Eng. Coor.  Rec/Store/Packaging		Engineering Quality Other	
NCN NO.					Tronk Gradi Gpacio	<b>'  </b>				_	2.164	_	
Root		Description of work order update Initial			Ac	ction	Sign &						
Cause	Date	Step	Qty	•	or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator								<u> </u>					
Material								i					
Setup								I					
Other								I					
Process								: <b>İ</b>			ŀ		
Supplier													
Training													
Unapproved			l			<u> </u>				1			
					F	AULT	CATE	GORY					
Landir	ng Gear				General				_	=	_		
ļ	Bending				Bend	Щ	Grain			Ovalized	_	Pressure/Forced	
	Centre Not Concentric to O/S			o/s	BOM/Route		Hardware			Over/Under tolerance Temperatu		Temperature/Cure	
	Cracks				Broken/Damaged	_	Inspection Incomplete			Part Incorrect Weld			
	Crushed/Crimped.				Burrs	-	Instructions Incomplete/Unclear		/Unclear			Wrong Stock Pulled	
	Cuffs			Contamination	Щ	Maintenance			Part Moved		•		
	Heat Treat				Countersink		Mislabe	led	<u> </u>	Positioned Wrong			
	Inspection Strip in Tube				Cut Too Short	Ш	Misread			Power Loss/	'Surge	Other	
	Ripples in Bend			Drill Holes	<del></del>	Offset							
	Torque W	aves in E	xtrusio	ո <u> </u> _	Drawing	$\square$	Out of 0	Calibration					
	Turning S	equence			Finish	$\square$	Out of S	Sequence				<u></u>	
i	Wave/Tw	ist in Tub	e		Folio	1 6	Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE				QA Closed:	Date:	
Work Order:					DISPOSITION						
Part No					Rework Scrap Use-as-is Work Order Update	4	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Shing Rec/Store/Packaging		Engineering Quality Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											

**FAULT CATEGORY** 

Grain

Hardware

Mislabeled

Misread

Offset

Inspection Incomplete

Maintenance .

Out of Calibration

Out of Sequence

**Outside Dimensions** 

Instructions Incomplete/Unclear

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part Incorrect

Part Moved
Positioned Wrong

Part Lost/Missing

Power Loss/Surge

Over/Under tolerance

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

**Landing Gear** 

Bending

Cracks

Cuffs

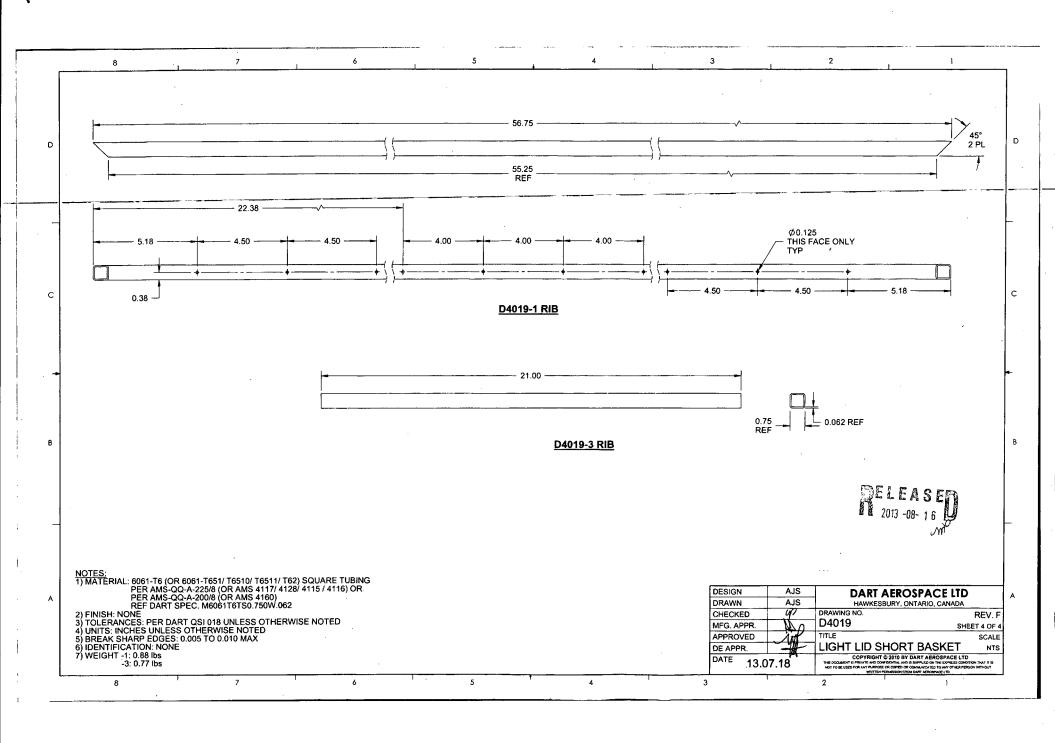
Heat Treat

Crushed/Crimped\_

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S



		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		0 4 61 1	D - 4	

									QA Closed:	Date	•		
Work Orde	ork Order:						AGAINST DEPARTMENT/PROCESS						
Part No	o			······································	Rework Scrap Use-as-is Work Order Update	- I	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root	Desc			Descri	iption of work order update	Initial	Initial Action		Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	hief Eng Description		Date	Verification	QC Inspector		
Doc/Data Equip/Tooling					A Commence								
Operator Material				-									
Setup Other											1		
Process Supplier													
Training	$\exists$												
Unapproved									]				
					F	AULT CATE	GORY						
Landin	g Gear				General				_				
	Bending				Bend	Grain		· .	Ovalized	L	Pressure/Forced		
_	Centre Not Concentric to O/S				BOM/Route	Hardw	are		<b>├</b> ── <b>├</b>		Temperature/Cure		
	Cracks				Broken/Damaged	Inspec	tion Incomplete				Weld		
Ĺ.	Crushed/CrimpedBurrs				Burrs	<del></del>	Instructions Incomplete/Unclear			Part Lost/Missing Wrong Stock Pulle			
<u> </u> _	Cuffs Contamination				$\vdash$	enance	ļ	Part Moved					
L	<del></del>				Countersink	Mislab	eled		Positioned \	_			
·	Inspection Strip in Tube Cut Too Short				Misread Power Loss/Surge Other								
Ļ	Ripples in Bend Drill Holes				Offset								
	Torque Waves in Extrusion Drawing					Out of Calibration							
<u> </u>	Turning S				Finish	<b>⊢</b> −−	Sequence						
	Wave/Twist in Tube Folio					Outsid	e Dimensions						